

Work Order ID 84844

May-24-12 7:58:37 AM

84844

Page 1

Item ID: D3697-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support Plate, RH

Start Date: 24/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/28

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3697

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3697Dwg Rev: B Prog Rev: B

6061.050

***grain direction along 3.44" ***

2- Deburr if necessary

4

0

Jm

12-6-15

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4

0

Jm 12-6-15

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/26/15

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Stop ***NS2***

Item Name: Support Plate, RH

Start Date: 24/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00				(4)			Sh 12/06/19
130									
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3697								
140	QC5- Inspect part completeness to step on W/O	0.00				4			12/02/21
140									
QC	Memo	0.00							
Quality Control									
150	Small Fab	0.00				4x			12/07/14
150									
Small Fab	Memo	0.00							
Small Fab	1- counter sink hole as per dwg D3697								

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Page 3

Item ID: D3697-4

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Support Plate, RH

Stop ***NS2***

Start Date: 24/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

5/26/12

4x

-7

4x

12-7-5

12/7/12

12-07-05

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May-24-12 7:58:41 AM

Page 1

Work Order ID: 84844

84844

Parent Item: D3697-4

D3697-4

Parent Item Name: Support Plate, RH

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.050

Purchased

No

100

sf

194.6640

0.4569

1.923789

**

M6061T6S 050

6061-T6 .050 Sheet

Jm 12-6-12

Location

Loc Qty

Loc Code

021

118.5

1211920

118.5

MAT021

76.164

114799

61.164

114993

15

114799

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Dart Aerospace Ltd

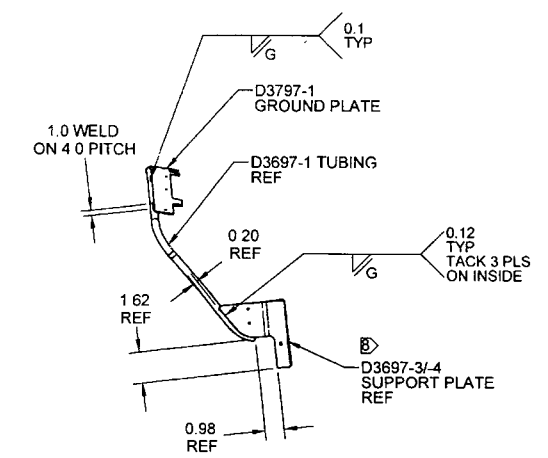
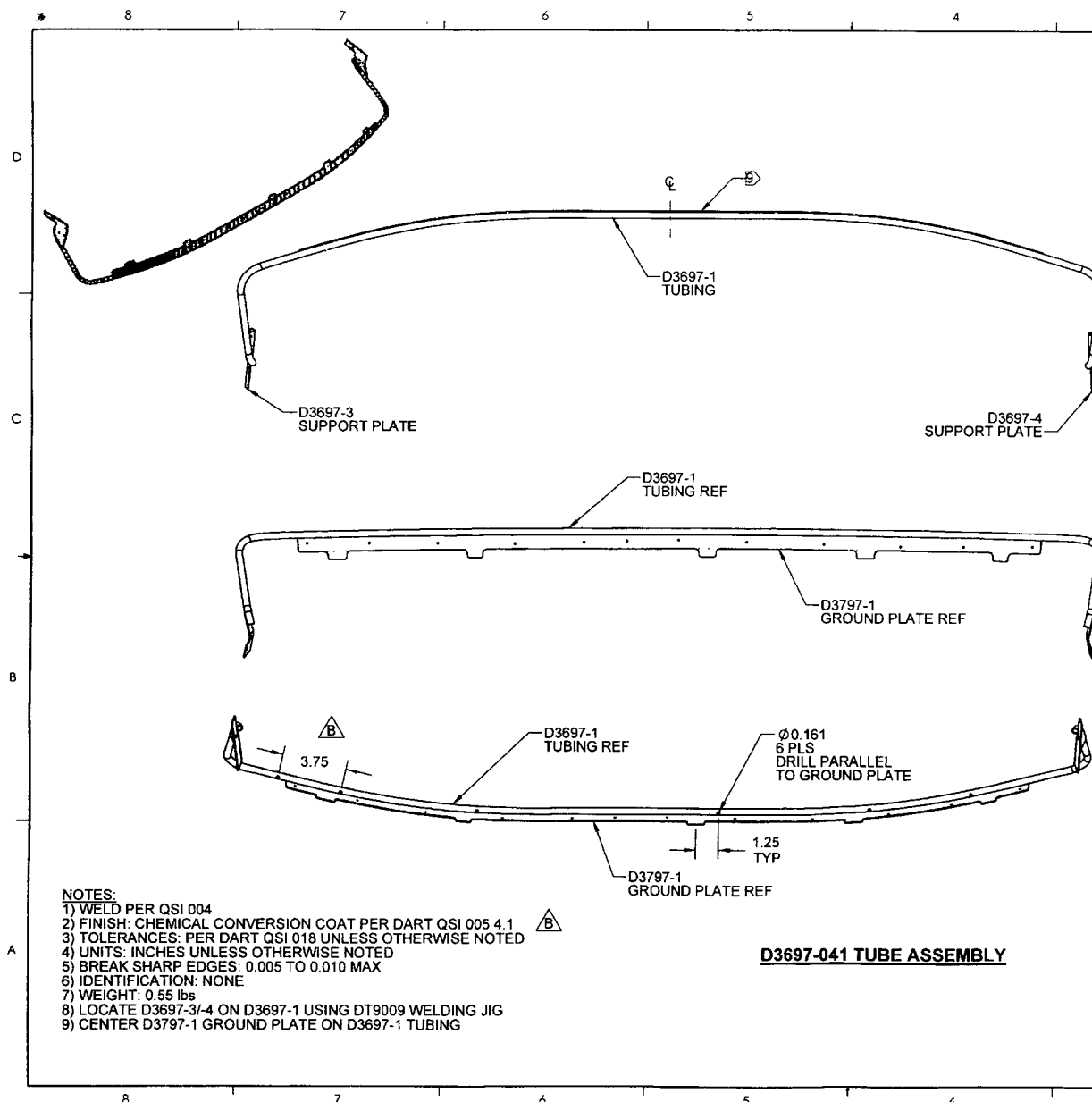
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RELEASED
05-07-08 MJD

PART LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

- NOTES:**
- 1) WELD PER QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.55 lbs
 - 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
 - 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY

B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A,8, ADD Ø0.161 HOLE. SHEET 1 ZONE B,7	RF	08 06.02
A	NEW ISSUE	RF	08 05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3697	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR	RF	TUBE ASSEMBLY	NTS
DATE	08.06.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 89894 MJS
12/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

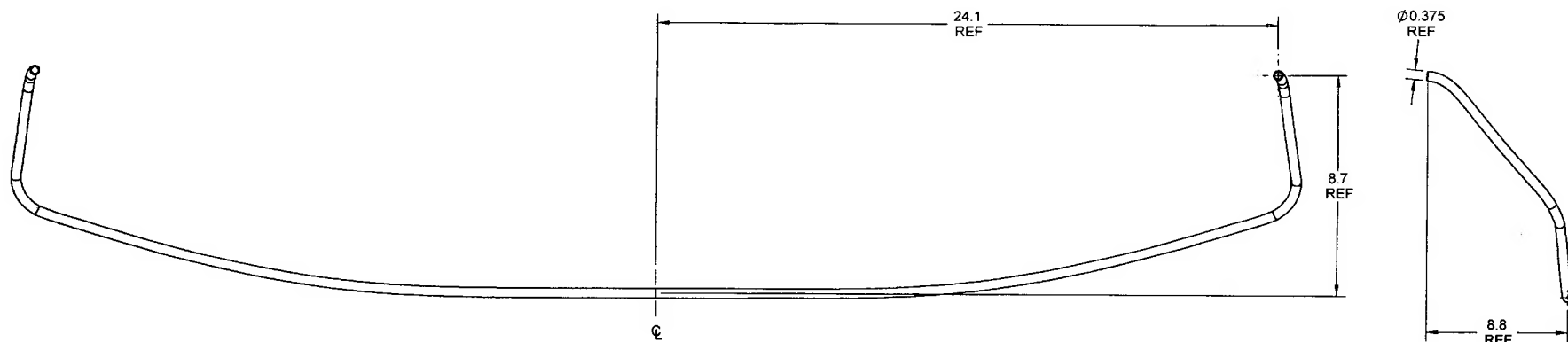
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

27244



D3697-1 TUBING

RELEASED
10.07.08

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (WWW-T-700/6) ALUMINUM TUBING $\varnothing 0.375 \times 0.049$ WALL (REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3697	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLY	NTS
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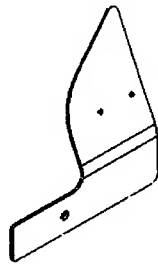
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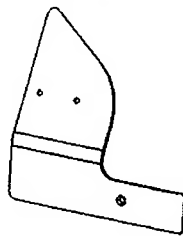
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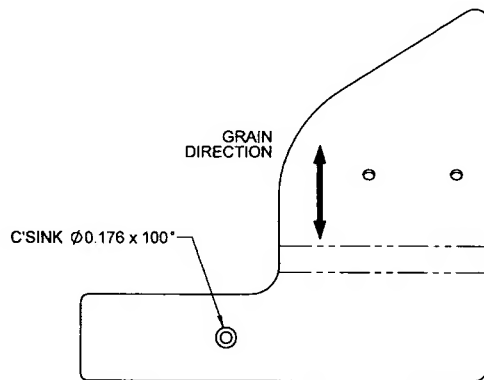
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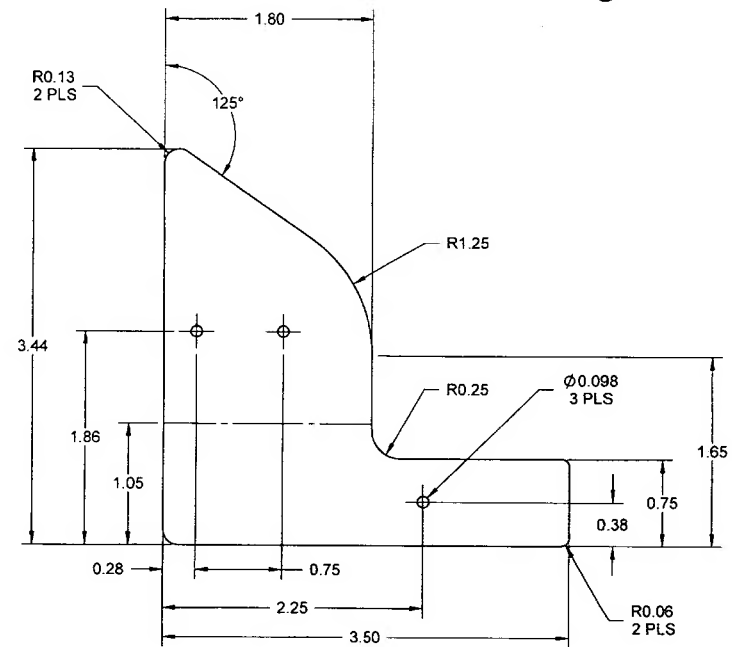
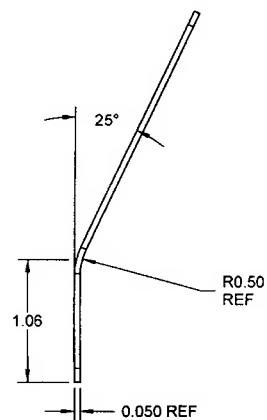
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. B
MFG. APPR.	RE	D3697	SHEET 3 OF 3
APPROVED	UP	TITLE	SCALE
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